November 18, 2009 12:38:17 PM Item ID: D2579 Accept Setup Start Ε **Revision ID:** Stop Itein Name: Crossbolt Spacer Stac Date: 18/11/2009 Start Qty: 160.00 **Cust Item ID:** kequired Date: 25/11/2009 Reg'd Oty: 160.00 **Customer:** Reference: Run Start Date: 04/1-/ **Process Plan:** Tooling: Date: Approvals: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Reject Reject Set Up/ Draw Plan Draw Accept Insp. Stamp Description Qty Qty Number Work Center ID **Run Hours** Number Rev. Code **Draw Nbr Revision Nbr** D2579 Rev E 100 0.00 Hardinge CNC LATHE SMALL 161 0 N 05/12/01 Hardinge Memo Hardinge CNC Lathe Small Machine as per Folio FA245 110 QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 2001201 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 161 0.00 Memo Quality Control

Dart Aerospace Ltd

	-								
W/O:	WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									:
			104						·
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	4:	Date:	
Resolution:			Dispositi	on:	QA: N/C Closed: Date:				
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCI	R)			····
DATE	STEP	Describtion of NC			tion B	Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

E

Page 2

November 18, 2009 12:38:17 PM Item ID: **Revision ID:** Item Name: Start Date: Required Date: 25/11/2009 Reference: Approvals:

D2579

Accept



Setup Start

Stop



Crossbolt Spacer

18/11/2009 Start Qty: 160.00

Req'd Oty: 160.00

Cust Item ID:

Customer:

Process Plan: Date:_____

Tooling: SPC (Y/N): Date:

Date:

Run Start

Reject

Qty

Stop



Sequence ID/

Operation Work Center ID Description Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Qty Code

Accept

Reject Number

161 B BE 09/12/03

Insp. Stamp

125

Skidtubes

Memo

OC: Date:

0.00

0.00

Skidtubes

1- clean crossbolt spacer with ultra brigth aluminum cleaner before storing.

130

Packaging Packaging

Memo

0.00

0.00

161 & BE 09/2/03

140

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location 4

0.00

Quality Control

Memo

0.00

a gr.12.03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							,	
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					- 10 - 10				1 100 11191	
					.4					
					100					
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes	No DQ	A :	_ Date: _	
Resolution: Disposit										
NCR:			WORK ORI	DER NON-CONFOR	RMANCE	(NCR)			
DATE	OTED	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	Section		Chief Eng	QC Inspector
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				11.	:			-A.Y		
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										775 775
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NOTE: Date & initial all entries

Picklist Print

November 18, 2009 12:38:25 PM

Work Order ID: 53780

Parent Item:

D2579RevE

Parent Item Name: Crossbolt Spacer

Comments:



Start Date: 18/11/2009

Required Date: 25/11/2009

Page 1

Start Qty: 160.00

Required Qty: 160.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	435.9000	60.3453			

6061-T6 RD Tube .500 x.058W

Warehouse	Loc Qty	Loc Code
Location		ļ
Main Warehouse		1
MAT	435.9	·
110335	0.6	ì
111757	11.61	
1 - 112652	123.69	
9 110000	200	

30ft 5/0V12101

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE By					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
, 				All the second s				_		
Part No		PAR #:	Fault Cat	egory:	_ NCR: `	Yes N	lo DQ /	4 :	_ Date: _	
	Re	esolution:	Dispositi	on:	QA: N/C Closed: Date:					
NCR:		1	WORK ORI	DER NON-CONFORMA	ANCE (I	ICR)				
DATE	STEP	Description of NC	Description of NC Corrective Action			Section B Verifi			Approval	Approval
	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33780
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype

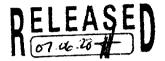
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.070	+/-0.030	4.071	/			
0.058	+/-0.010	.058				
	,					
		<u></u>				
		,				
			-			
					·	

Measured by:	Audited by:	-7m	Prototype Approval:	N/A
Date: STZ/ST	Date:	04/12/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM	E



DESIG	SN ##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED 11	APPROVED.	DRAWING NO. REV. E
	-#	#	D2579 SHEET 1 OF 1
DATE			TITLE SCALE
07.	04.17		CROSS BOLT SPACER 1:1
Α		96.09.16	NEW ISSUE
В		96.12.05	0.065 WALL WAS 0.035 WALL
С		97.02.21	0.058 WALL WAS 0.065 WALL
D		99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)
Ε		07.04.17	UPDATE NOTES



	4.070±0.030
Ø0.500 Ø0.384 (REF)	
0.058	SHC

D2579 CROSS BOLT SPACER

UNCONT SUBJECT V/11

ENC

D2579 CROSS BOLT SPACER

MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF DART SPEC M6061T6T0500W058)

2) FINISH:

NONE

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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